Technical Data Sheet

MM700FG

2 Part Silicone moulding putty food grade 37 Shore A

Introduction

This is a paste 2-part addition cure food grade silicone elastomer system. After mixing parts 'A' and 'B' in the correct proportions, the system will cure at ambient temperatures within 24 hours. The cured rubber exhibits excellent physical and properties and is ideal for use as a moulding rubber for confectionary and other food products.

FDA compliance

If approved for food use all components present in the fully cured product are listed in CFR 21, 175.300," Resinous and polymeric coatings" and CFR 21, 177.2600," Rubber articles intended for repeated use". The fully cured rubber satisfies the requirements of CFR21, 175.300 and 177.2600, sub paragraphs (e) and (f) for applications involving both aqueous and fatty foods.

Key Features

- CFR21,177,2600 food approval for fatty and aqueous food
- EC 1935/2004 and EU 10/2011 compliant
- Putty like consistency
- Fast curing

Use and Cure Information

Measure the required amount of A and B parts by weight at the ratio of 1 :1 (A to B) in a clean plastic or metal container, knead until the colour of the mixture is uniform.

Curing Conditions

The following table offers a guide to the rate of cure at various temperatures, kneading of the components at normal ambient room temperatures is recommended to ensure adequate working time for handling. The pot life can be extended to several hours by chilling the components

Inhibition of Cure

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be

inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

Property	Test Method	Value
Uncured product		
Appearance		**Putty**
Colour A Part		**White**
Colour B Part		**Blue**
Cure Type		**Addition**
De-Mould Time Hrs		**0.75 hrs**
Max Cure Hrs @ 25 °C		**4 hrs**
Max Cure Mins @ 100 °C		**15 mins**
Mix Ratio		**1:1**
Pot Life mins		**15 mins**
Cured product		
After 48hrs cure at 23°+/-2°C and 50+/-5% humidity		
CTE Linear ppm/°C		**155 ppm/°C**
CTE Volumetric ppm/°C		**465 ppm/°C**
Colour		**Blue**
Duro Shore A	ASTM D 2240-95	**37**
Elongation %	ISO 37	**220 %**
FDA	CFR (21] 177.2600	**Yes**
Linear Shrinkage %		**0.1 %**
Max Working Temp +°C	AFS_1540B	**200 °C**
Min Working Temp - °C		**50 °C**
Modulus Youngs MPa		**1.5 MPa**
SG	BS ISO 2781	**1.36**
Tear kN/m	BS ISO 34-1	**12 kN/m**
Tensile MPa	ISO 37	**2. MPa**
Storage		
Max storage temperature °C		**30 °C**
Shelf life		**12 mths**

Health and Safety

Safety Data Sheets available on request.

Packaging

ACC Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.

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